



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2893-1
Job Sheet 180865



Part No: D2893-1

Job Qty: 12 ea

Part Name: Support



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/17/18

Job Tracking No:

Due Date: 8/3/18

Created By: Marie Lajeunesse

Type: ~~Stock~~ **SOLD**

Description:

Note: DWG REV C IPP: C 02.11.26 Reformat; Added P/O KJ IPP D 06.04.19 removed alodine EC IPP Rev:E Added priming as per Rev B 07-04-30 JLM IPP F 08.03.19 Re-format EC verified by: DD IPP Rev:G 08-05-15 add QC14 DD verified by:EC IPP Rev:H 11.08.04 as per dwg rev.C DD ver:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	8/3/18	8/3/18	0.00	0.00	Start Up Machining-1		<i>mm</i>
100	CNC Vertical Machining	12 pcs	8/3/18	8/3/18	0.33	23.53	HAAS1-2		<i>mm</i>
120	QC	12 pcs	8/3/18	8/3/18	0.00	0.00	QC8 Machining-1		<i>mm</i>
130	Crosstubes	12 pcs	8/3/18	8/3/18	0.00	2.00	Crosstubes-2		<i>mm</i> 8/03/18
140	QC	12 pcs	8/3/18	8/3/18	0.00	0.00	QC3		<i>mm</i> 8/03/18
170	Packaging	12 pcs	8/3/18	8/3/18	0.00	0.00	Packaging3-1		<i>mm</i> 18-08-13
180	QC21-SA	12 Ea	8/3/18	8/3/18	0.00	0.00	QC21		<i>mm</i> 18-08-13

Part Op 100 - 1-Machine as per Folio FA081

Descriptions: 130 - Per note 8 on page 1 of dwg D2893, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg.

170 - LOCATION : LG050

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK078	D2893-1 Turning Detail	6 Ea (.5 ea)	90-Start up Operation	

5079545

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	DSK078	6	6	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.750 Support	2.985Inches	+ 0.020 - 0.000	3.005 2.985	
2	2.750 Support	0.440Inches	+ 0.020 - 0.000	0.460 0.440	
3	2.750 Support	0.125Inches	+ 0.035 - 0.000	0.160 0.125	
4	2.750 Support	0.040Inches	+ 0.020 - 0.000	0.060 0.040	
5	2.750 Support	0.188Inches	+ 0.005 - 0.000	0.193 0.188	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

6	2.750 Support	0.125Inches	+ 0.035 - 0.000	0.160 0.125
7	2.750 Support	0.140Inches	+ 0.020 - 0.000	0.160 0.140
8	2.750 Support	1.360Inches	+ 0.040 - 0.000	1.400 1.360
9	2.750 Support	0.040Inches	+ 0.020 - 0.000	0.060 0.040
10	2.750 Support	1.190Inches	+ 0.040 - 0.000	1.230 1.190
11	2.750 Support	0.010Inches	+ 0.010 - 0.000	0.020 0.010
12	2.750 Support	0.053Inches	+ 0.020 - 0.000	0.073 0.053
13	2.750 Support	0.240Inches	+ 0.020 - 0.000	0.260 0.240
14	2.750 Support	2.518Inches	+ 0.020 - 0.000	2.538 2.518
15	2.750 Support	84.390Inches	+ 6.000 - 0.000	90.390 84.390
16	2.750 Support	0.261Inches	+ 0.005 - 0.000	0.266 0.261
17	2.750 Support	0.053Inches	+ 0.020 - 0.000	0.073 0.053

Plex 7/17/18 12:57 PM Dart.lajeunesse.marie



Container No: S098215



Part: D2893-1

Job No: 180865

Serial No/Batch: S098215

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/01/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By: _____	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

DART AEROSPACE LTD		Work Order: 180865
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		3.003	2.998	3.001	3.000	2.999
AB	0.440	0.460		0.450	0.458	0.455	0.455	0.456
AC	0.125	0.160		0.160	0.160	0.160	0.160	0.160
AD	0.040	0.060		0.050	0.049	0.048	0.049	0.051
AE	0.188	0.193		0.188	0.188 Ø	0.188 Ø	0.188 Ø	0.188 Ø
AF	0.125	0.160		0.145	0.142	0.142	0.142	0.141
AG	0.140	0.160		0.145	0.148	0.148	0.148	0.148
AH	1.360	1.400		1.376	1.378	1.378	1.377	1.378
AI	0.040	0.060		0.044	0.046	0.042	0.044	0.043
AJ	1.190	1.230		1.204	1.213	1.212	1.209	1.209
AK	0.010	0.020		0.010	0.010	0.010	0.010	0.010
AL	0.053	0.073		0.0625	0.063 R	0.063 R	0.063 R	0.063 R
AM	0.240	0.260		0.250	0.250 R	0.250 R	0.250 R	0.250 R
AN	2.518	2.538		2.525	2.538	2.538	2.538	2.538
AO	84.39	90.39		87.39	87.00	87.00	87.00	87.00
AP	0.261	0.266		0.261	0.261 Ø	0.261 Ø	0.261 Ø	0.261 Ø
AQ	0.053	0.073		0.0625	0.063 R	0.063 R	0.063 R	0.063 R
AR								
AS								
AT								
Accept/Reject								

Measured by: MM **Date:** 20/8/08

Audited by: mmr L **Date:** 15/8/08

Preliminary Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order:	
Description: Ø2.750 Support		Part Number: D2893-1	
Inspection Dwg: D2893		Rev: C	
		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	61	72	83	94	105
HAAS Section								
AA	2.985	3.005		2.999	2.996	2.998	2.998	2.999
AB	0.440	0.460		.455	.455	.455	.455	.454
AC	0.125	0.160		.143	.141	.140	.141	.142
AD	0.040	0.060		.052	.051	.051	.050	.050
AE	0.188	0.193		.188Ø	.188Ø	.188Ø	.188Ø	.188Ø
AF	0.125	0.160		.140	.140	.140	.141	.141
AG	0.140	0.160		.147	.142	.143	.146	.145
AH	1.360	1.400		1.378	1.377	1.377	1.376	1.376
AI	0.040	0.060		.044	.045	.045	.048	.046
AJ	1.190	1.230		1.210	1.210	1.211	1.212	1.211
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.063 R	.063 R	.063 R	.063 R	.063 R
AM	0.240	0.260		.250 R	.250 R	.250 R	.250 R	.250 R
AN	2.518	2.538		2.538	2.538	2.538	2.538	2.537
AO	84.39	90.39		87.00°	87.00°	87.00°	87.00°	87.00°
AP	0.261	0.266		.261Ø	.261Ø	.261Ø	.261Ø	.261Ø
AQ	0.053	0.073		.063 R	.063 R	.063 R	.063 R	.063 R
AR								
AS								
AT								
Accept/Reject								

Measured by: M.M. **Date:** 2018/09/07

Audited by: mmL **Date:** 16/08/18

Preliminary Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
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DART AEROSPACE LTD		Work Order:	
Description: Ø2.750 Support		Part Number: D2893-1	
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		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
HAAS Section								
AA	2.985	3.005		3.000	3.000			
AB	0.440	0.460		.455	.455			
AC	0.125	0.160		.141	.141			
AD	0.040	0.060		.050	.051			
AE	0.188	0.193		.188	.188			
AF	0.125	0.160		.140	.141			
AG	0.140	0.160		.146	.147			
AH	1.360	1.400		1.377	1.376			
AI	0.040	0.060		.047	.047			
AJ	1.190	1.230		1.210	1.211			
AK	0.010	0.020		.010	.010			
AL	0.053	0.073		.063 R	.063 R			
AM	0.240	0.260		.250 R	.250 R			
AN	2.518	2.538		2.538	2.538			
AO	84.39	90.39		87.00	87.00			
AP	0.261	0.266		.261	.261			
AQ	0.053	0.073		.063 R	.063 R			
AR								
AS								
AT								
Accept/Reject								

Measured by: <u>MM</u>	Date: <u>20/8/09/01</u>
Audited by: <u>mark</u>	Date: <u>19/08/08</u>
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
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